Date: User:

Wednesday, 2/15/2006 9:16:18 AM

Linda Lacelle

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 25266

**Estimate Number** 

: 10949

P.O. Number

First Issue

Written By

**Previous Run** 

: NIA

: 2/15/2006 This Issue Prsht Rev.

: NC

: 12/15/2005

:NA

S.O. No. : NIA

Type

: MACHINED PARTS

Part Number

**Drawing Name** 

: D2493 : D2493 REV A

: PATIENT STOP ASSEMBLY

**Drawing Number Project Number** 

: N/A **Drawing Revision** 

Material **Due Date**  : MA : 1/10/2006

Qty:

Each

Checked & Approved By

Comment

:SER ABOVE USER : Est. C 03.01.17 Reformat: Incorporated D2492 KJ/RF

:SEE COMMENT BELOW

**Additional Product** 

Job Number:



Seq. #:

1.0

**Machine Or Operation:** 

Description: 5052-132 .080 Sheet

M5052H32S080



36:3669 sf(s) Total:

Comment: Qty.: 1.9140 sf(s)/Unit 5052-H32 .080 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.080" thick

(M5052H32S.080)

Batch

SHEAR

2.0

SHEAR

3.0

Comment: SHEAR

Identify as D2492

Shear blanks: 8.000" x 25.942

INSPECT PARTS AS THEY COME OFF MACHINE



Machine per Folio FA041 and Dwg DX492

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BRAKE NC



**Comment: NC BRAKE** 

Deburr

Form using Jig DT24/92B

**POWDER COATING** 

POWDER COATING



5.0

Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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					i					
Part No		PAR #: Fault Category:	NCR: Yes	No DO	<u> </u>	Date:				

Part No:	PAR #:	Fault Category:	NCR: Yes No Do	QA:	Date:
			QA: N/C Clos	ed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						WORK ORDER NON-CONFORMANCE (NCR)			
	Description of NC	Corrective Action Section B		Varification	A	A				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Corrective Action Section B Sign & Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Chief Eng Chief Eng Chief Eng Corrective Action Section B Sign & Date Chief Eng Ch	STEP Description of NC Section A Initial Chief Eng Chief			

Date: Wednesday, 2/15/2006 9:16:18 AM User: Linda Lacelle **Process Sheet** Drawing Name: PATIENT STOP ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 25266 Part Number: D2493 Job Number: Seq. #: **Description: Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION D2444 Pip Pin Assembly 7.0 2.0000 Each(s)/Unit Total: 38.0000 Each(s) Comment: Qty.: Pip Pin Assembly Pick: **Qty Part Number** Description 25811 11 D2444 Pip Pin D2492 8.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 19.0000 Each(s) Patient Stop Pick: Description Batch **Qty Part Number** B 25271 D2492 Patient Stop 9.0 AN960JD10 Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s) Washer Pick: Qty Part Number Description Batch AN960JD10 2 Washer MS21042L3 10.0 Comment: Qty.: <u> (38)</u> 2.0000 Each(s)/Unit Total: 38.0000 Each(s) Nut Pick: Description Batch Qty Part Number MS21042L3 <u>M 1218</u>0 Nut 11.0 MS27039107 Screw Comment: Qty.: 38.0000 Each(s) 2.0000 Each(s)/Unit Total: 28 Screw Pick: Batch 2) M 11660 Description Qty Part Number MS27039-1-07 Screw

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAP	NGES				*
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	): 	PAR #: Fault Category:	NCR: Ye	s No DQ	A:	∑ Date: ₫	56/02/20
			QA:	N/C Close	ed:	Date: _	

Approval	Anneced
Approval Chief Eng	Approva QC Inspecto

er: Lind	a Lacelle	Process Sheet	
Customer:	CU-DAR001 Dart Helicopters Service	Drawing Name: PATIENT S	STOP ASSEMBLY
Job Number:	25266	Part Number: D2493	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comme	nt: SMALL & MEDIUM FAB RESO	URCE 1	THE STATE OF THE S
	Assemble as per Dwg D2493. I Identify as D2493	D2492 on BOM as material listed in Step 2.	50 06/02/15
13.0	QC5	INSPECT WORK TO CURRENT STEP	
			/206-02-13
Comme	nt: INSPECT WORK TO CURREN	T STEP	
14.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comme	nt: PACKAGING RESOURCE #1	1	
	Identify and Stock Location:S+179	// 6/2/17	7 (9)
15.0	DC	DOCUMENT CONTROL	
Comme	nt: DOCUMENT CONTROL Inspection Level 21	ue 06/02/20 (9)	Doulos
b Completion			

## Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	HANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
-								
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	Α:	Date:		

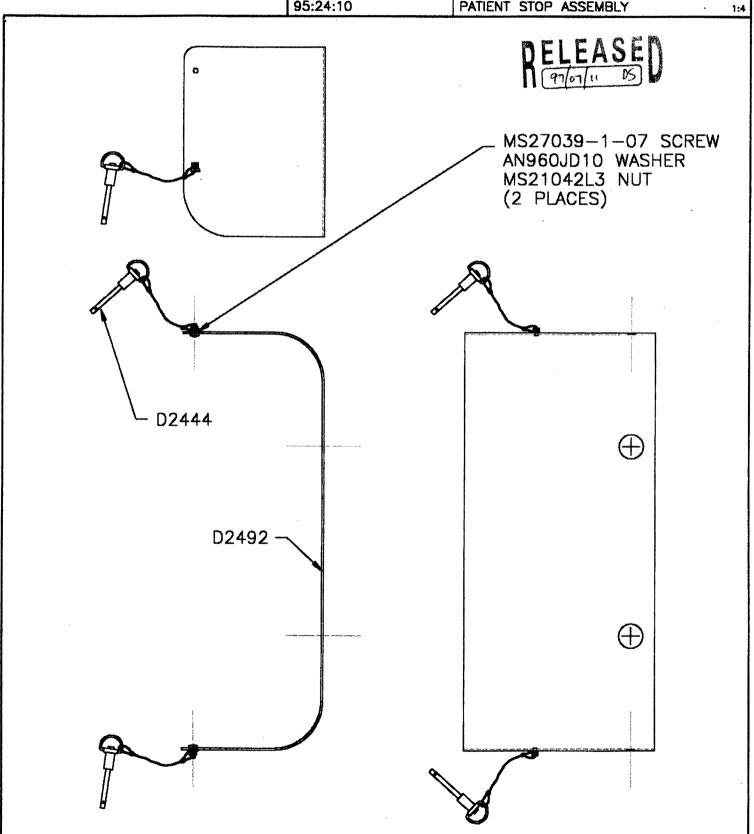
Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
		· .	QA: N/C C	losed:	Date:
	10.00				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						WORK ORDER NON-CONFORMANCE (NCR)			
		Description of NC	Corrective Action Section B		Description of NC Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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DESIGN B WILLIAMS	DRAWN BY  B WILLIAMS	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,				
CHECKED	APPROVED	DRAWING NO.	<del>dring</del>	R	EV.	Ā
bre)	$\mathcal{A}$	D2493	SHEET	1	OF	1
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Dart Aerospace Ltd. Thursday, 12/15/2005 3:57:18 PM Kim Johnston User: **Process Sheet** : PATIENT STOP ASSEMBLY Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 25266 : 10949 **Estimate Number** : D2493 Part Number P.O. Number . D2493 REV A This Issue : 12/15/2005 S.O. No. : **Drawing Number** : NC : N/A **Project Number** Prsht Rev. : MACHINED PARTS : A : // Type **Drawing Revision** First Issue Material Previous Run **Due Date** : 1/10/2006 Qty: 2 Um: Each Written By Checked & Approved By : Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF Comment **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** 1.0 M5052H32S080 5052-H32 .080 Sheet Comment: Qty.: 1.9140 sf(s)/Unit Total: 3.8281 sf(s)5052-H32 .080 Sheet Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <u>11405</u> SHEAR 2.0 Comment: SHEAR Shear blanks: 8.000" x 25.942 Machine per Folio FA041 and Dwg D2492 Identify as D2492 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE BRAKE NO NC BRAKE Comment: NC BRAKE Deburr Form using Jig DT2492B

POWDER COATING

POWDER COATING

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Dart Aerospace I
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W/O:		WORK ORDER O	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #· Fault Category:	NCP: Voc	No DO	۸.	Data	

					QA: N/	C Closed:	Date: _		
NCR:	NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E		Verification	A 1		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Thursday, 12/15/2005 3:57:18 PM Date: User: Kim Johnston **Process Sheet Drawing Name: PATIENT STOP ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 25266 Part Number: D2493 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 D2444 Pip Pin Assembly Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pip Pin Assembly Pick: **Qty Part Number** Description Batch Pip Pin 2 D2444 8.0 D2492 Patient Stop Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Patient Stop Pick: **Qty Part Number** Description Batch D2492 Patient Stop AN960JD10 Washer 9.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Batch Qty Description Part Number Washer 2 AN960JD10 10.0 MS21042L3 Nut Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Nut Pick: Qty Part Number Description Batch MS21042L3 11.0 MS27039107 Screw Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Screw Pick: Qty Part Number Description Batch MS27039-1-07 Screw

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W/O:		WORK ORDER CHAN	NGES				
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Part No		PAR #: Fault Category:				Date:	<del></del>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annroval	Annroyee
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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				•		·		
•								

Date:

Thursday, 12/15/2005 3:57:18 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Job Number:



Seq. #:

**Machine Or Operation:** 

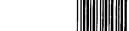
Description:

Part Number: D2493

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

13.0

14.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_

ĎC 15.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



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W/O:		WORK ORDER CH	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
			QA:	N/C Close	d:	_ Date: _	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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